



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3913-041
Job Sheet 167244-A



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/27/17

Job Tracking No:

Due Date: 11/17/17

Created By: Mario Poulin

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/16/17	0.00	0.00	Start Up Large Fab2		12/13/17
100	Large Fab	1 pcs		11/16/17	0.00	10.00	Large Fab 1		12/13/17
110	QC	1 pcs		11/16/17	0.00	0.00	QC9		12-17-14
120	QC	1 pcs		11/16/17	0.00	0.00	QC5		17-12-14
125	HandFinish	1 pcs		11/16/17	0.00	0.29	HandFinish2		17-12-18
130	Powdercoat	1 pcs		11/16/17	0.00	0.93	Powdercoat2		17-12-18
140	QC	1 pcs		11/16/17	0.00	0.00	QC3		17-12-18
150	HandFinish	1 pcs		11/17/17	0.00	0.50	HandFinish4		12/12/19
160	QC	1 pcs		11/17/17	0.00	0.00	QC5		17-12-19
170	Packaging	1 pcs		11/17/17	0.00	0.00	Packaging3		17-12-19
180	QC21-SA	1 Ea		11/17/17	0.00	0.00	QC21		DAS DEC 19 2017

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick Kit

1138467 START: 3:40 / ODT: 3:50 FINISH: 3:55

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2581 5005842	2	16	0	0
	D3913-1 5002297	1	15	0	0
	D3913-15 5014390	1	10	0	0
	D3913-3 5002108	1	17	0	0
	D3913-7 5009710	2	2	0	0
	D3913-9 5010881	1	8	0	0
	D3916-041 5015623	2	2	0	0
	D3916-5 5012242	3	10	0	0
	D4016-1 5009181	3	7	0	0
	D4017-7 5004270	3	15	0	0
	D4017-9 5009723	2	2	0	0
	D4020-11 5005857	2	0	0	0
	D4021-1 5010955	3	27	0	0
	D4034-041 5017545	1	1	0	0
	D4034-043 5017546	1	1	0	0
	D4672-1 5005866	2	3	0	0
	M304EX0.75-16F 5009863	33	638	0	0
	AN3-10A 5014736	6	256	0	0
150-HandFinish					

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISP(
Part No. _____	
NCR No. _____	Suspected l



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 Email: sales@dartaero.com
 www.dartaerospace.com

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Date : _____	Step #: _____
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Long Basket Base Assembly, 350

PART NO: D3913-041
Revision:
Operation: Start up Operation
Change No:

Mfg Date: 12/12/17
Job No: 167244-A

Approval

ed By

Supervisor
erification

ordinator
roval

Description Work Order Deviation

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐								
Misidentified	☐	Past Due	☐	OTHER :							

FM135942-1 →

D2931	FM135-1	2	1,336	0	0
D4021-5	50218B3	2	18	0	0
MS20600-AD4W3	5019131	2	319	0	0
MS21042L3		6	862	0	0
NAS1149F0332P	5020003	12	3,231	0	0

Part Specifications

Specifications could not be found.

Plex 10/27/17 10:05 AM dart.poulin.mario

10/27/17
B. Poulin

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								